

# Work Order ID 68332



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Tuesday, April 12, 2011 9:59:47 AM

Item ID:	D3065-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	4/12/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	4/18/2011	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	4/12/12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3065	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3065	<input type="checkbox"/> Dwg Rev: B	<input type="checkbox"/> Prog Rev: B	<input type="checkbox"/> 2-					
2024, 2428	Deburr as required								(46)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8/11/12/29

can to  
(46)

1311-4-29

1311-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 4/12/2011	Start Qty: 40.00		Cust Item ID:		
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## Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00	SB	1105102		(46)			
Brake NC	Bend as per Dwg D3065								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

Count  
(46)

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Tuesday, April 12, 2011 9:59:47 AM

Item ID: D3065-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 4/12/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				46	0	11	4/10/03
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				46		BR	11-5-3
180  Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u>  Memo	0.00  0.00		DB	4/10/04	(46)			

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries


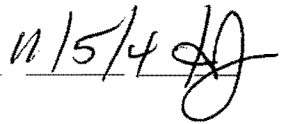
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Tuesday, April 12, 2011 9:59:47 AM

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Required Date: 4/18/2011      Req'd Qty: 40.00            Customer:  
Reference:

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_      Run Start   
QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_      Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/5/4 

11-05-3  
46

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, April 12, 2011 9:59:53 AM

Work Order ID: 68332



Parent Item: D3065-1



Parent Item Name: Step Spacer

Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐C02.11.01 Incorporated D3066-1 IPP ☐KJ/RF ☐  
IPP: ☐D06.04.25 Water jet EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

97.0000

0.1238

5.212632

5.8



HB11-4-29

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

97

112291

0.5

112331

32.5

113162

64

112331

46

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	18332
<b>Description:</b> Step Spacer		<b>Part Number:</b>	D3065-1
<b>Inspection Dwg:</b> D3065 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.251	✓		V 1862	
2.093	+/-0.010	2.092	✓		V	
3.936	+/-0.010	3.934	✓		V	
4.186	+/-0.010	4.190	✓		V	
0.587	+/-0.010	.587	✓		V	
Ø0.128	+0.005/-0.001	.132	✓		V	
R0.125	+/-0.010	.125	✓		R.G.	
3.465	+/-0.010	3.460	✓		V	
Ø1.250	+0.012/-0.001	1.250	✓		V	
0.368	+/-0.010	.369	✓		V	
0.871 (Pitch)	+/-0.005	.870	✓		V	
0.040	+/-0.010	.040	✓		V	

<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>
<b>Date:</b> 11-4-09	<b>Date:</b> 11/04/09	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

# Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

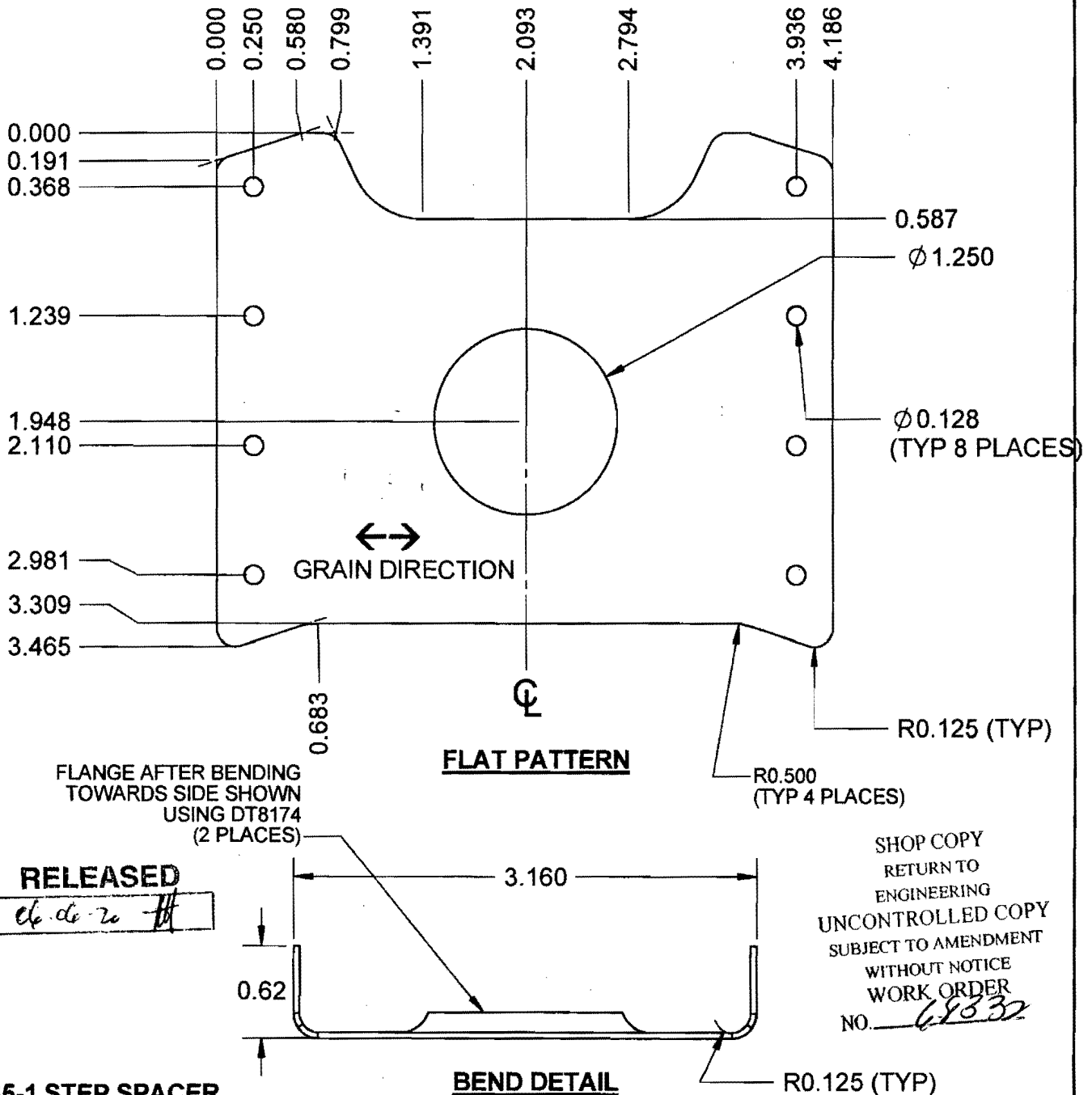
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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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